

Date: Tuesday, 15/07/2008 9:15:17 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING	
Job Number : 40486-2		
Estimate Number : 10844		
P.O. Number :	Part Number : D2249041	
This Issue : 15/07/2008 S.O. No. :	Drawing Number : D2249 REV. E	<i>split 5 mfr.</i>
Prsht Rev. : NC	Project Number : N/A	
First Issue : / /	Drawing Revision : E	
Previous Run : 34671	Material :	
Written By :	Due Date : 22/07/2008	Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08. 15.08</u>		
Comment : Est: D 05.02.04 Added Step 9 KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22491	Lug
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(X5)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Lug ~~B 34115~~ → 10

*Cpl 08-07-31*

2.0	D22493	Base Plate
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(X5)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Base Plate ~~B 34115~~ → 10 ~~B 22499~~ → 4 ~~B 31485~~ → 1 ✓

*Cpl 08-07-31*

3.0	D22495	Gusset
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(X5)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Gusset ~~B 31607~~ → 4 ~~B 31485~~ → 4 ✓ ~~B 31031~~ → 6 ✓

*Cpl 08-07-31*

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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(X5)

Comment: LARGE FABRICATION RESOURCE 1  
 Weld as per Dwg D2249 and QSI 004

*Cpl 08-07-31*

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

*10 08-07-31 (5)*

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*S 08-07-01 (X5)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 15/07/2008 9:15:17 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 40486

Part Number: D2249041

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 POWDER COATING POWDER COATING



M108523



(5X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15  
400 °F  
9:45

m-l 08/08/05

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5)

Comment: INSPECT POWDER COAT

fz 08/08/05

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57198A

10 8/8/05 (5)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

Dec 08/07

mf 08-08-06

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

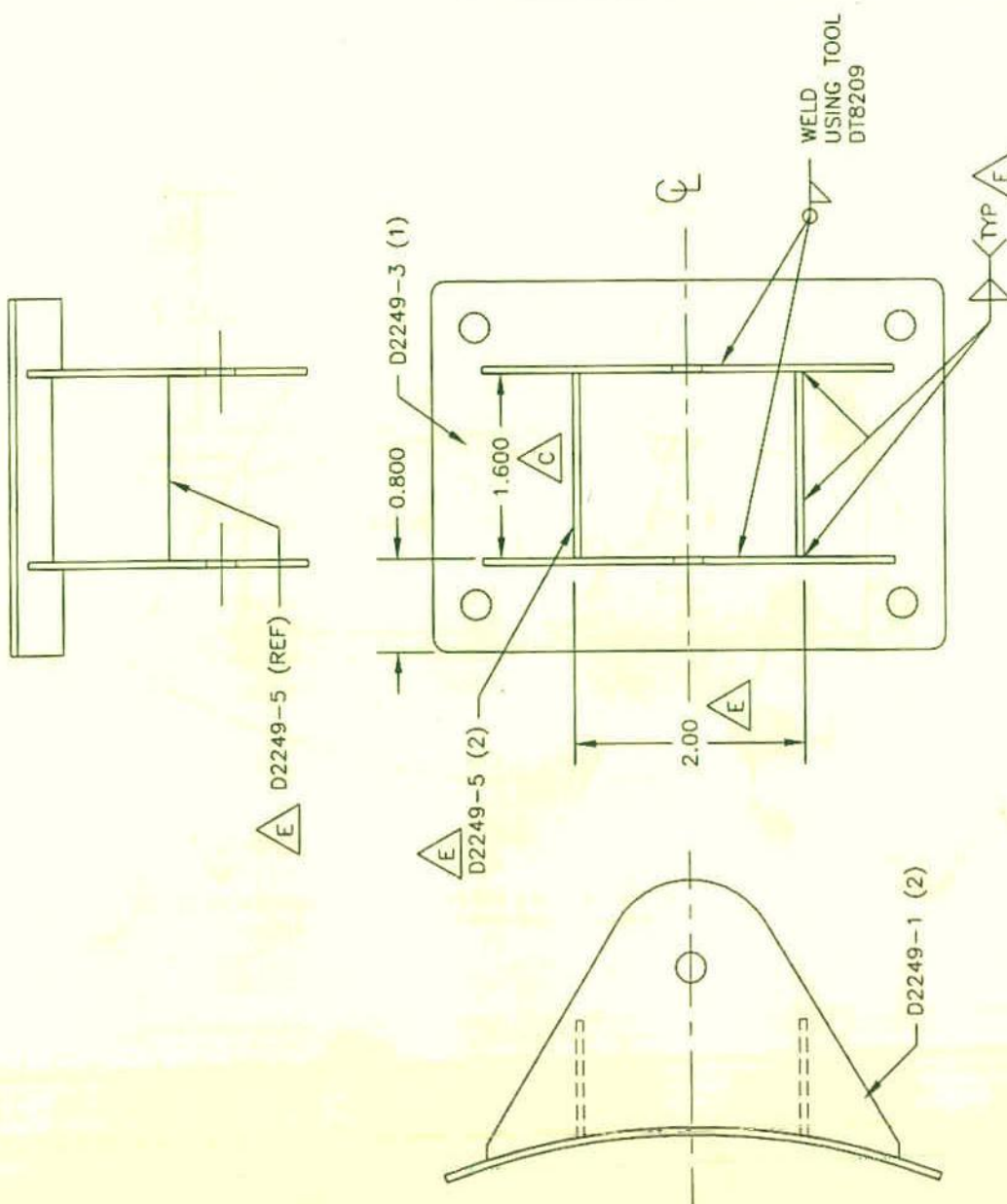


**DART**



**RELEASED**  
99.10.12 KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2249	REV. E SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

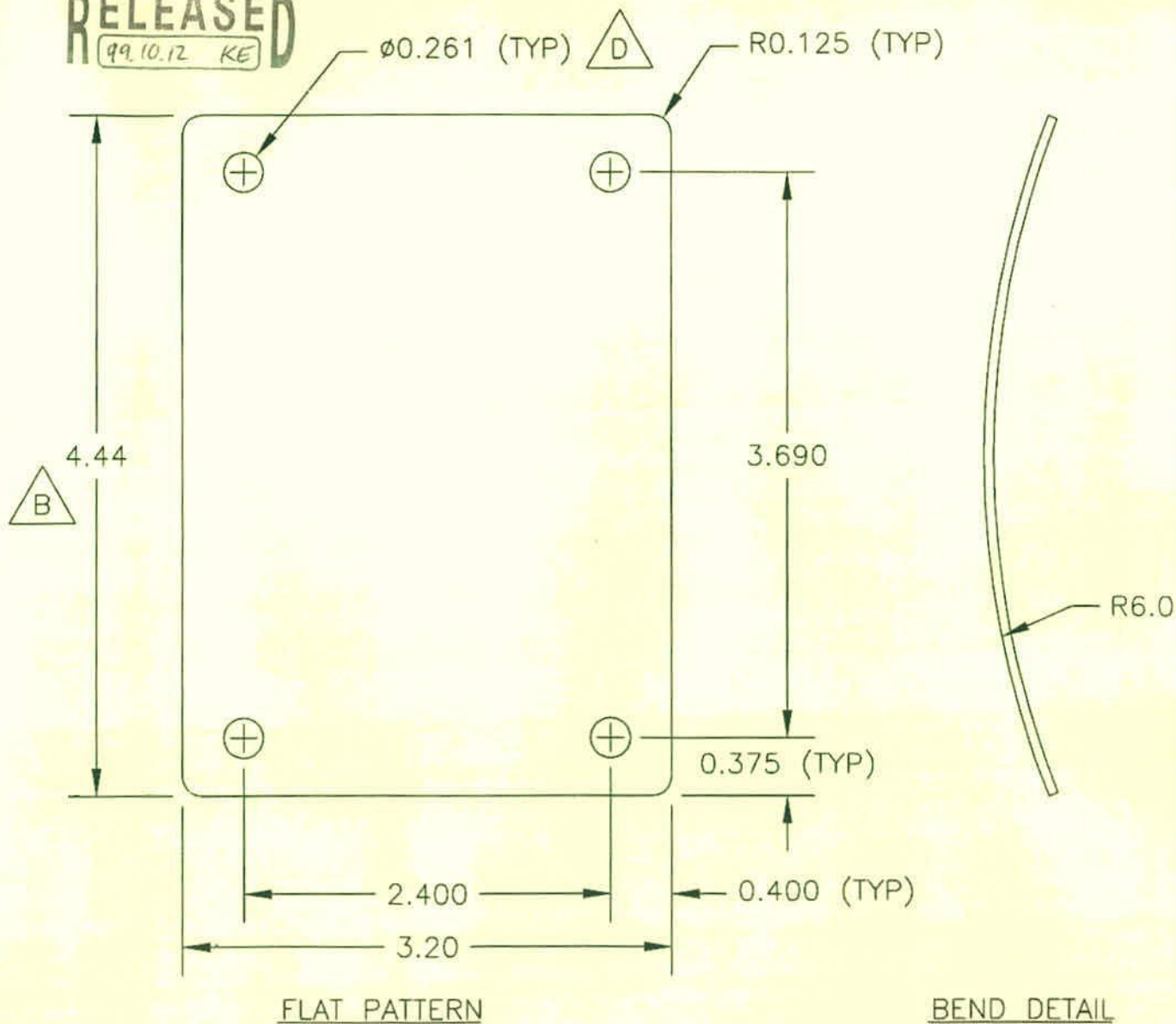
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WORK ORDER  
NO. 40786





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CHECKED <i>KE</i>	APPROVED <i>H</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED  
99.10.12 KE



D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

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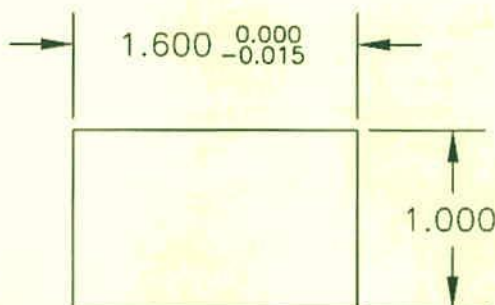






DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>TH</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
49.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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